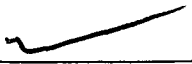
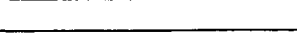


Date: Monday, 6/26/2006 1:48:24 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY
 Job Number : 27686
 Estimate Number : 10699
 P.O. Number : *N/A* Part Number : D3391025
 This Issue : 6/26/2006 S.O. No. : *N/A* Drawing Number : D3391 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : E
 Previous Run : 27641 Material : *N/A*
 Due Date : 7/15/2006 Qty: 1 Um: Each
 Written By : 
 Checked & Approved By : 
 Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC
 Est Rev:C 06-03-28 Update Manufacturing Instructions JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6014090 ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch
 1 D6014-090 Extrusion B26546

Identify as D3391-3

MS 06/08/15

1

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: D & Dwg D3391 Rev: E

MS 06/08/16

1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/08/16

1

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: E

2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

MS 06/08/25

1



Date: Monday, 6/26/2006 1:48:24 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 27686

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2nd 06/08/25

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Er 06/08/25 x 1

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 6-8-29

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 6-8-30

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

pm '06-08-31(1)

DP 6-8-30

pm '06-08-31(1)

pm '06-08-31(1)

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jul 09 05 01

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-a 06/10/14

(1)

Date: Monday, 6/26/2006 1:48:24 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 27686

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YLM 06/11/17 X1

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 11 17 ①

14.0

NAS1330C3KB166

INSERT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
8	NAS1330C3KB166	Insert	18626

18626

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per dwg

FC 06 11 17 ①

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 11-17 ①

17.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
14	AESS10KB366	Insert	101248

101248

18.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB266	Insert	17905

17905

or NAS1330C3KB266

Date: Monday, 6/26/2006 1:48:24 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 27686

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty

Part Number

Description

Batch

2

AESS10KB316

Insert

17905

or NAS1330C3KB316

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part Number

Description

Batch

1

D2646

Aft Cap

28041

21.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C4A

Bolt

101390

22.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty

Part Number

Description

Batch

2

AN960C10L

Washer

1013410

23.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty

Part Number

Description

Batch

2

NAS1515H3L

Washer

1014118

Date: Monday, 6/26/2006 1:48:24 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 27686

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

FC

2-Install Aft Cap as per Dwg D3391

A/ R Sikaflex-241/-291 102660

Sikaflex expiry date: 02/07

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-11-17 (1)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

04/14/17 (1)

27.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/11/17 (1)

Job Completion



06-11-17

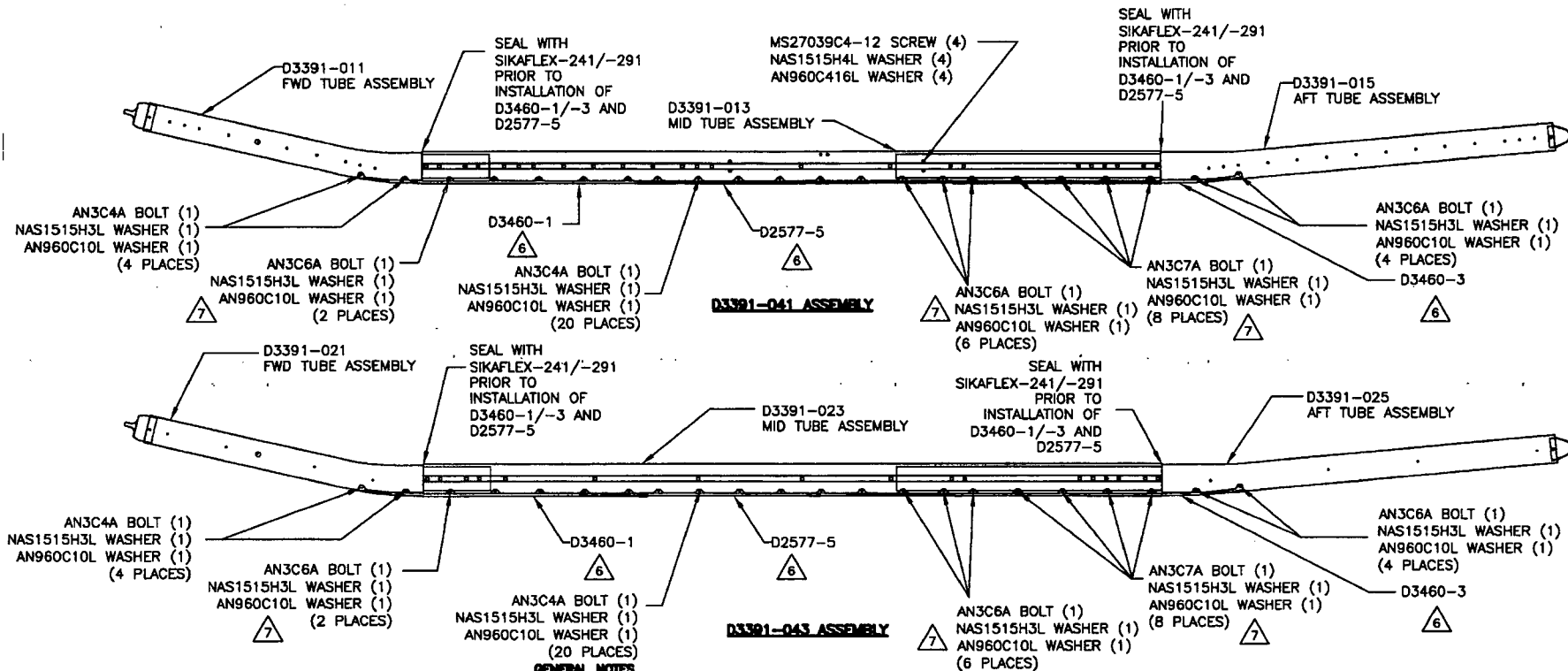
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

- GENERAL NOTES**
- ALL DIMENSIONS ARE IN INCHES
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
 - USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C'SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
 - APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
 - DO NOT TORQUE, HAND TIGHTEN ONLY

△

RELEASED

06.05.03

E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.04.25	TITLE 412 FLOAT SKIDTUBE
		DRAWING NO. D3391
		SCALE NTS

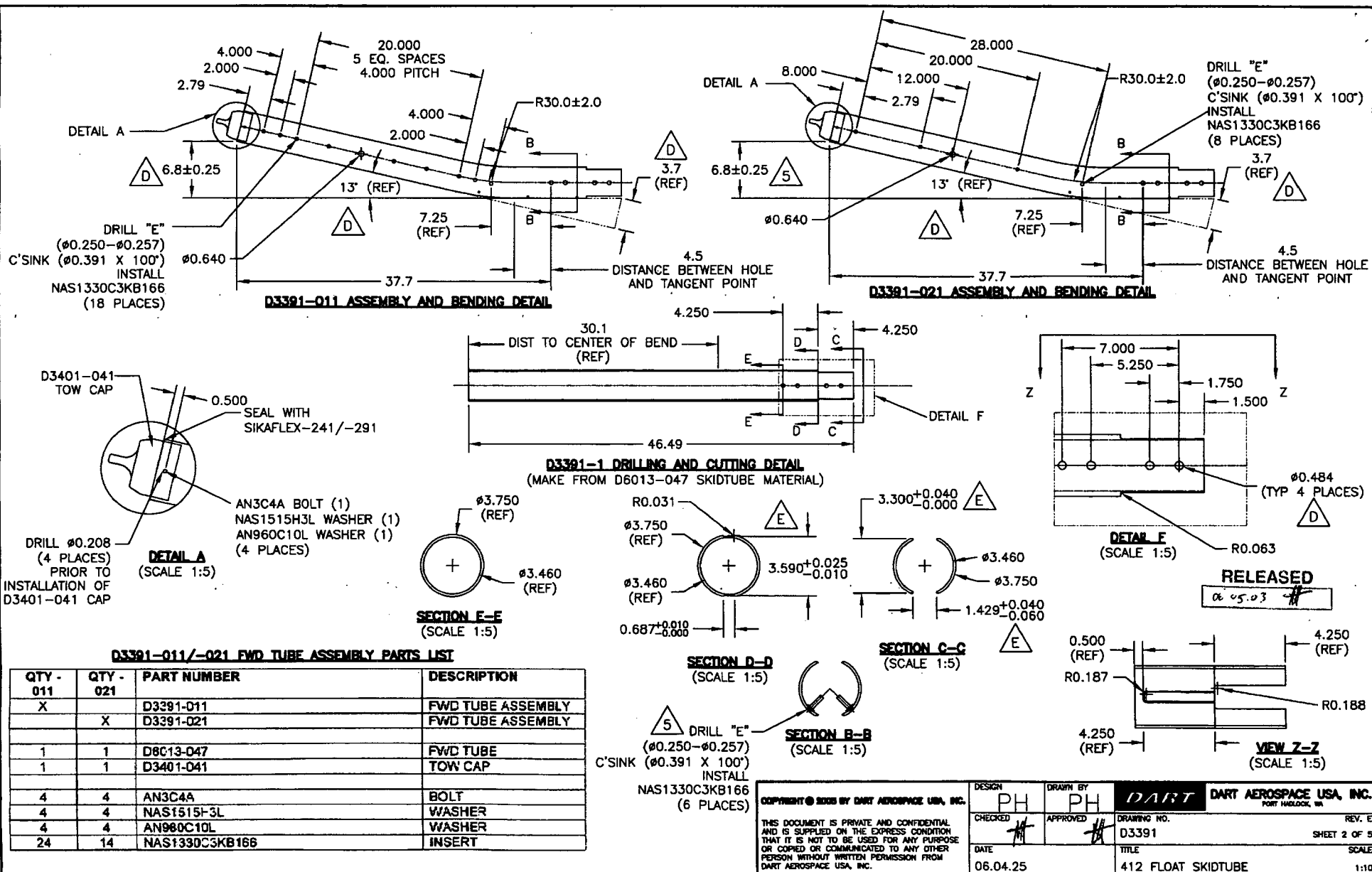
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DART DART AEROSPACE USA, INC.
PORT HANCOCK, PA

REV. E

SHEET 1 OF 5



DESIGN PH PH DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

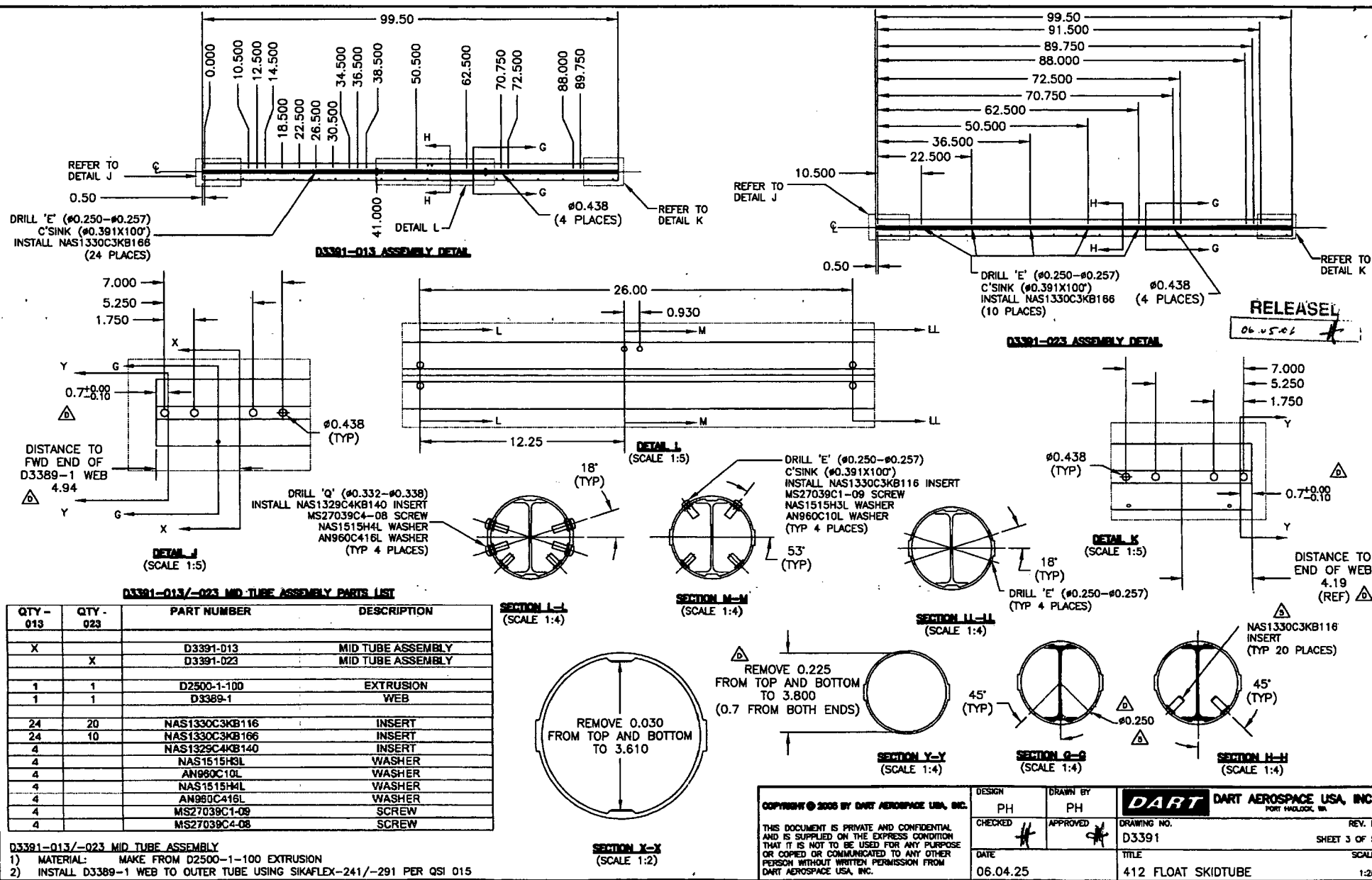
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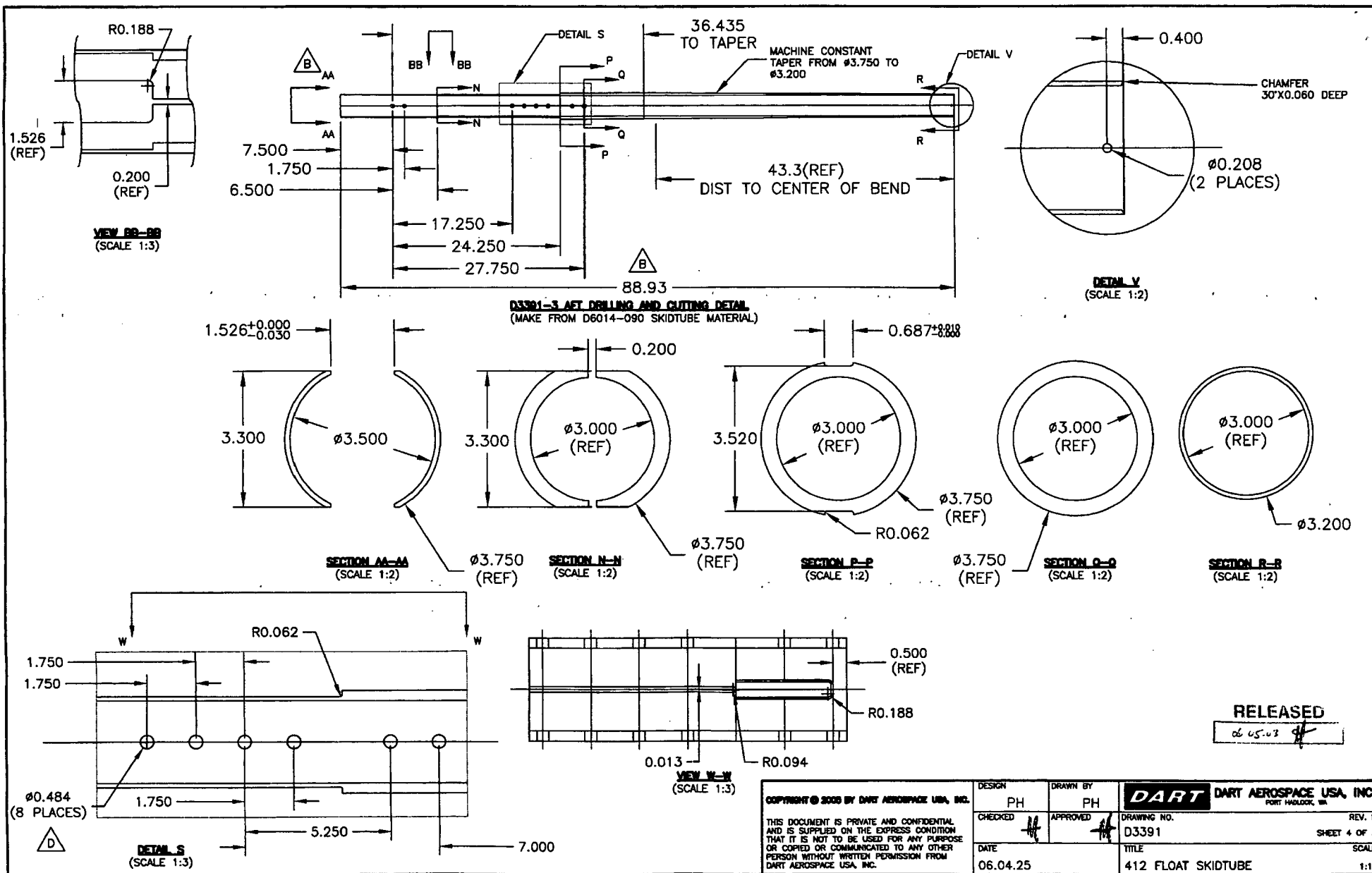
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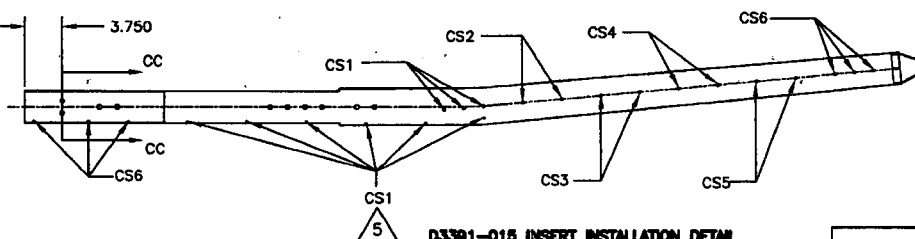
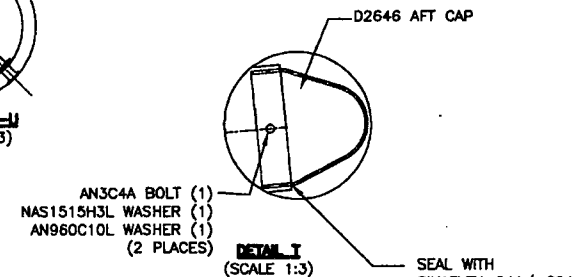
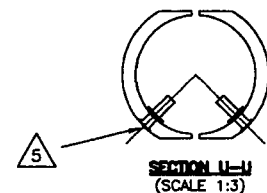
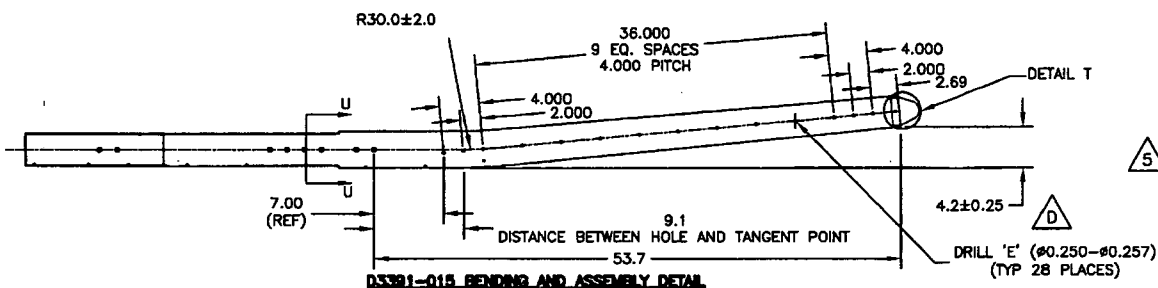
DATE 06.04.25

TITLE 412 FLOAT SKIDTUBE

REV. E SHEET 2 OF 5 SCALE 1:10





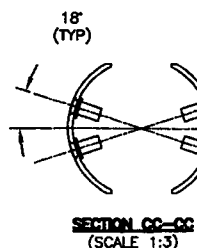


C'SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

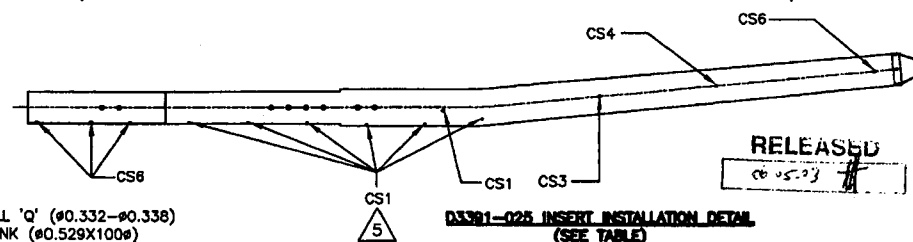
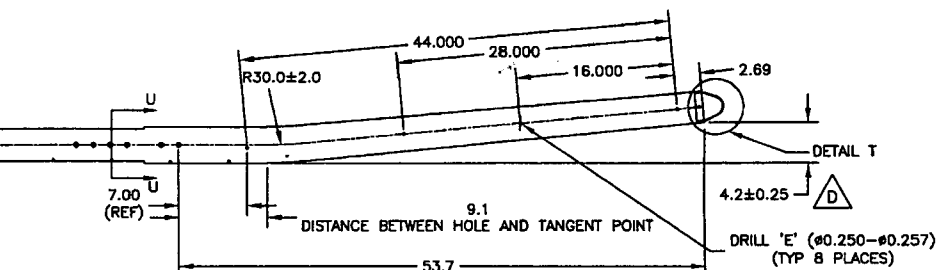
HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB398
CS2	4	2	Ø0.391	AESS10KB398
CS3	4	2	Ø0.391	NAS1330C3KB316
CS4	4	2	Ø0.391	NAS1330C3KB266
CS5	4	2	Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB398	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4	2	NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4	2	NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100#)
NAS1330C4KB151 INSERT (1)
(4 PLACES)



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DESIGN PH
CHECKED PH
DATE 06.04.25

DRAWN BY PH
APPROVED
DRAWING NO. D3391
TITLE 412 FLOAT SKIDTUBE
REV. E
SHEET 5 OF 5
SCALE 1:12

RELEASED
06-05-03

DART AEROSPACE LTD		Work Order:	
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.497	✓			
88.93	+/-0.030	88.92	✓			
44.995	+/-0.030	45.00	✓			BG
3.200	+/-0.010	3.194	✓			BG
1.526	+0.000/-0.030	1.528	—			
0.200	+/-0.010	0.203	—			
7.500	+/-0.010	7.499	—			
27.750	+/-0.010	27.750	—			
31.750	+/-0.010	31.750	—			
35.250	+/-0.010	35.250	—			
0.400	+/-0.010	0.395	—			
00.208	+0.005/-0.001					
3.300	+/-0.010	3.305	—			
0.200	+/-0.010	0.202	✓			
3.520	+/-0.010	3.521	✓			
0.687	+0.010/-0.000	0.687	—			
R0.062	+/-0.010	R0.062	—			
Ø0.484	+0.005/-0.001	Ø0.484	—			

Measured by: BG / JLM	Audited by: ET	Prototype Approval:	N/A
Date: 06/08/25	Date: 06/08/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	